

DART AEROSPACE LTD	Work Order:	256 22
Description: Fitting	Part Number:	D3257-1
Dwg: D3257 Rev. A	Qty:	10
Ref:		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required			
2	MV	Cut blank: 0.500" x 0.500" x 1.180" long Bar Material: AISI 303 SS Bar (M303B0.500x0.500) Identify for D3257-1 Batch: M17625	SA	06.03.27 06.03.21	10 6
3	MV	Machine as per Folio FA420 and Dwg D3257	JL	06.04.03	10
4	QC2	Inspect parts as they come off the CNC machine Identify as D3257-1	JL	06.04.03	10
5	MV	Deburr	JL	06.04.03	10
6	QC8	Second check	ARK	06/04/03	10
7	ST	Identify and Stock 70c ST 418	U	06/4/5	10
8	AC	Cost / part _____	U	06/04/05	10
9	DC	Close W/O Inspect Level 21	D	06/04/06	10

Rev	Date	Change	Revised By	Approved
A	04.04.14	New issue	KJ/RF	

REFERENCE ONLY

Date: Wednesday, 1/25/2006 1:22:12 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FITTING
Job Number :	25622		
Estimate Number :	11160		
P.O. Number :		Part Number :	D32571
This Issue :	1/25/2006	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3257 REV A1
First Issue :	//	Project Number :	N/A
Previous Run :		Drawing Revision :	A1
	Type :	Material :	
	MACHINED PARTS	Due Date :	2/15/2006
Written By :		Qty:	6 Um: Each
Checked & Approved By :	<i>06.01.25</i>		
Comment :	Est: A 04.04.14 New issue KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M303B0500X0500	AISI 303 Bar .5 x .5
-----	----------------	----------------------



Comment: Qty.: 0.1147 f(s)/Unit Total : 0.6880 f(s)

AISI 303 Bar .5 x .5

Material: AISI 303 SS Bar

(M303B0.500x0.500)

Identify for D3257-1

Batch: *M17625**SD**06.02.21*

2.0	BAND SAW	BAND SAW
-----	----------	----------

**Comment:** BAND SAW

Cut blank: 0.500" x 0.500" x 1.180" long Bar

Machine as per Folio FA420 and Dwg D3257

Deburr

*SD**06.02.21**6*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 06/04/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/25/2006 1:22:12 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 25622

Part Number: D32571

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

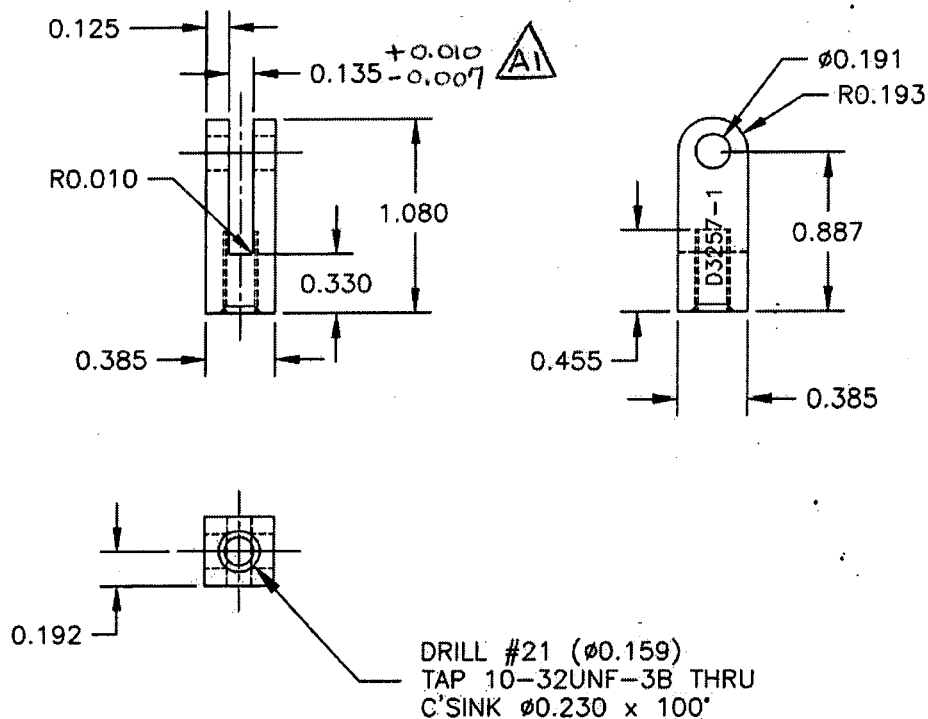
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3257	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE FITTING	SCALE 1:1
A	04.01.27	NEW ISSUE	
AI	04.12.14	ADD TOLERANCE	

RELEASED
04.04.05**D3257-1 FITTING****NOTES:**

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: AISI 303 SS, BAR (REF DART SPEC. M303B0.500X0.500)
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE DART P/N AS SHOWN

SHOP COPY
RETURN TO
ENGINEERING

CONTROLLED COPY

SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO 25622

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

